TANK TYPE	MOUNT	LOCATION
Diaphragm	Lugs, 3	Girth

NORTHROP GRUMMAN

This is a 22-inch spherical pressure vessel constructed of 6Al-4V titanium. Positive fuel expulsion is provided by a reversible ethylene-propylene terpolymer (AF-E-332) rubber diaphragm retained (welded in) at the sphere mid-plane. Mounting is accomplished by three (3) lugs parallel with and adjacent to the sphere mid-plane.

ISO 9001 & AS 9100 REGISTERED

Part Number 80409-1

SIZE: 22.14-inch ID Sphere
SIZE: 562-mm

APPLICABLE DOCUMENTS

Acceptance Test Procedure	50-000534
Cleaning	CPP 3867

DIAPHRAGM INFORMATION

Diaphragm P/N	80-263027-1
Diaphragm Mold P/N	T-1868
Diaphragm Gross Wt	7.6 lbs
Diaphragm Matl Type	AF-E-332
Material Specification, Rubber	MT3-73
Diaphragm Processing Note 2	90-000094
N-Ray Procedure	1002

Notes:

1: Lockheed Martin Spec 55-02461
2: Proprietary Document
3: 'Tube Protector SK 1135 & SK 1136
4: Fracture Critical

TANK CHARACTERISTICS

Operating Pressure, psig	475	Total Volume, ci	5,555
Proof Pressure, psig	795	Prop Volume, ci	4,754
Cryo Proof, psig	NA	Max Design Wt, lbs	21.00
Burst Pressure, psig	950	Minimum Wall, inch	0.030

TANK CHARACTERISTICS (Metrics)

Operating Pressure, Bar	32.75	Total Volume, l	91.03
Proof Pressure, Bar	54.81	Prop Volume, l	77.91
Cryo Proof, Bar	NA	Max Design Wt, Kg	10.98
Burst Pressure, Bar	65.50	Minimum Wall, MM	0.76

FORGINGS

FORGINGS P/N	SUPPLIER	Die No
80-203061-1		

RING FORGING	RING SIZE, (Rough Machined)
80-298063-1	25.81 +.09 x 22.38 -.09 ID x .71 +.06 LG

TUBE TYPE AND SIZE

TRANSITION	SIZE
80-409001-1	.375 OD x .028 Wall
80-409001-3	.375 OD x .028 Wall 9.525 x .711 mm

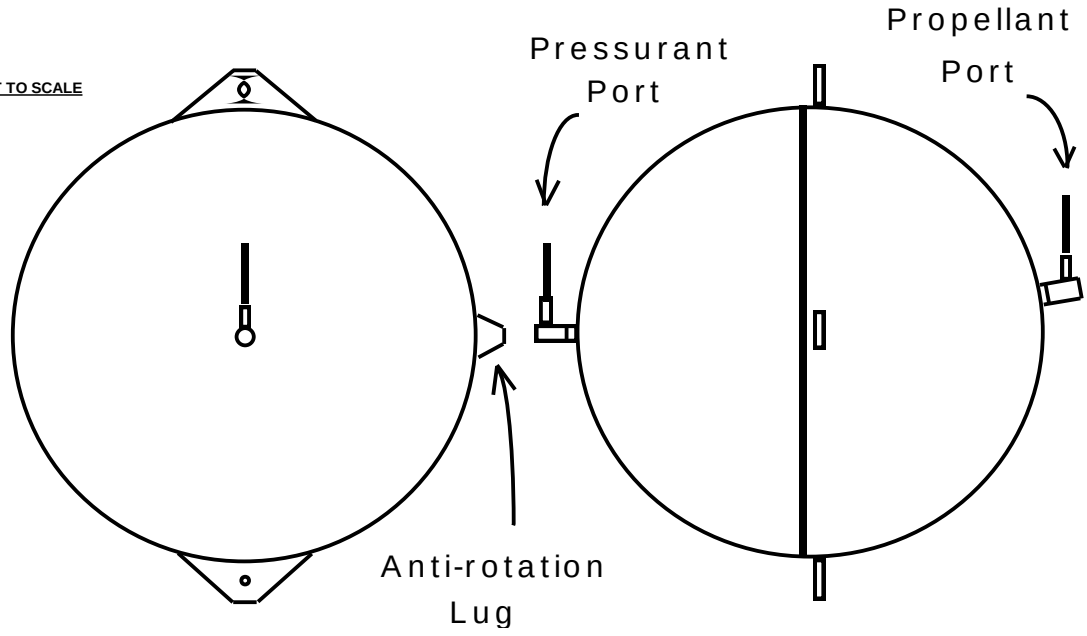
ACCEPTANCE TESTS

- Examination of Product
- Pre-Proof Volume Determination
- Proof Pressure Test
- Post-Proof Volume Determination
- Water Expulsion Test
- Internal (Diaphragm) Leakage
- External Leakage Test
- Final Examination of Product
- Weight Determination
- Cleanliness Verfication
- Post Test Inspection

QUALIFICATION TESTS

Qual by 80298-1

SKETCH NOT TO SCALE



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